

Work Order ID 65491

January 18, 2011 3:13:12 PM



Page 1

Item ID: D3472-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Flap

Start Date: 1/18/11 Start Qty: 4.00



Cust Item ID:

Required Date: 1/31/11 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 1/10/11 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3472	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg D3472 ☒ Dwg Rev: A ☐ Prog Rev: A

2024.040

1B 11-1-27

5

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1B 11-1-27

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Salas 27

45

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65491

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Page 2

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Small Fab

5

Small Fab

Memo

0.00

Small Fab

1- Deburr 2-Bend as per dwg D3472 3-Buff-out any marks due to bending

SB 11/01/07

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

SB 11/01/25

5

150

0.00



Chemical Conversion Coat per QS1005 4.1

HandFinish

Memo

0.00

Hand Finishing

2) JH 11/01/31

NS

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 18, 2011 3:13:12 PM

Page 1

Work Order ID: 65491



Parent Item: D3472-1



Parent Item Name: Flap

Start Date: 1/18/11

Required Date: 1/31/11

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev. A 06.02.02 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	216.4595	0.0546	0.229895			



2024-T3 .040 sheet



KB11-1-07

Location

Loc Qty

Loc Code

MAT

28.2

114415

28.2

MAT22

188.2595

110305

21.93

111786

9.66

112291

28.25

112331

52

113162

76.4195

112291

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

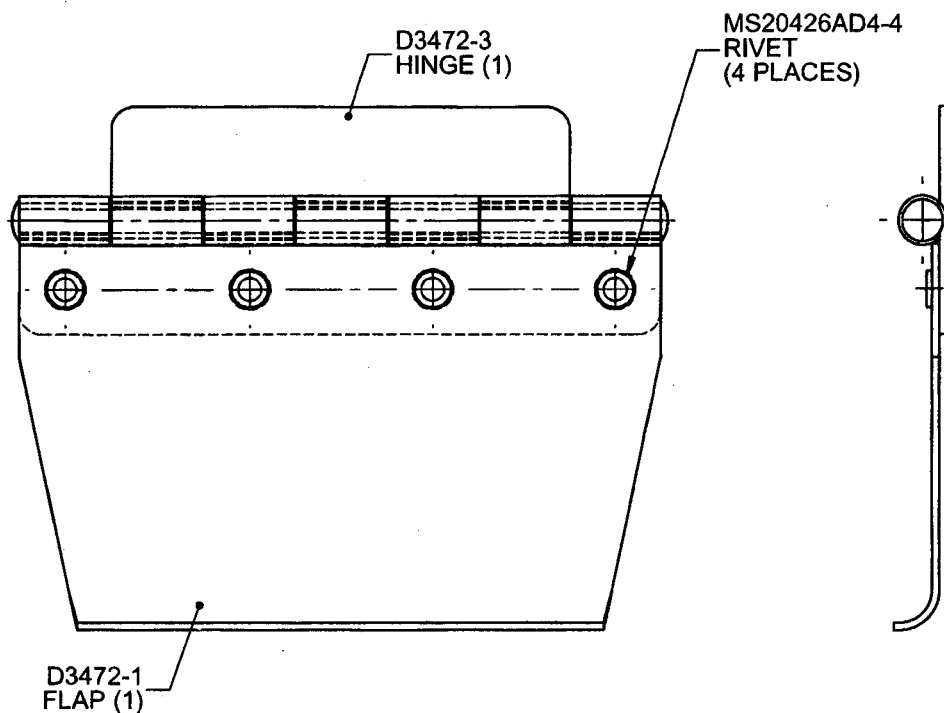
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3472	REV. A SHEET 1 OF 4
DATE 06.01.17		TITLE HEAT OUTLET DEFLECTOR	SCALE 1:1
A	06.01.17	NEW ISSUE	

06.04.03 *H*



D3472-041 CABIN HEAT OUTLET DEFLECTOR

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65491
C211/01/18

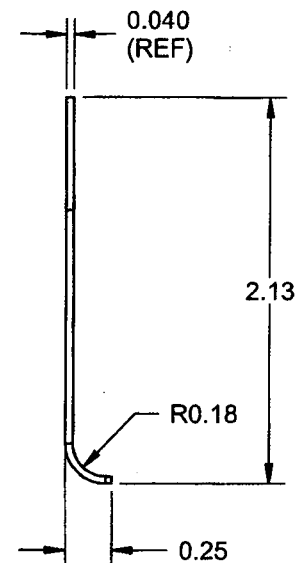
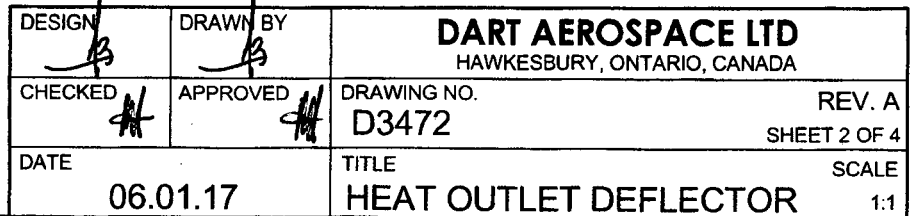
NOTES:

- 1) IDENTIFY WITH DART P/N D3472-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3472-041	CABIN HEAT OUTLET DEFLECTOR
1	D3472-1	FLAP
1	D3472-3	HINGE
4	MS20426AD4-4	RIVET

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**D3472-1 FLAP
BENDING DETAIL**

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WORK ORDER
NO. 68491

1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.040" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.040)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) PART IS SYMMETRICAL ABOUT CENTERLINE

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

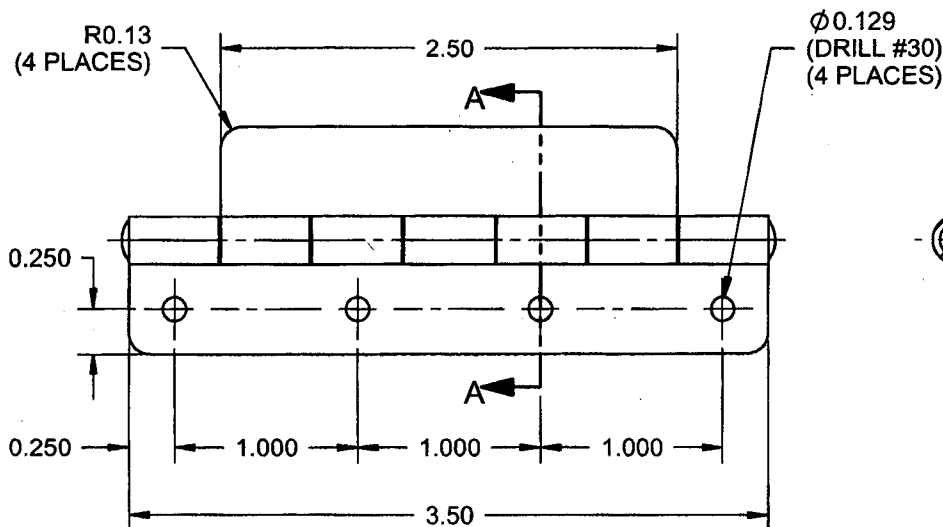
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3472	REV. A SHEET 3 OF 4
DATE 06.01.17		TITLE HEAT OUTLET DEFLECTOR	SCALE 1:1

06.04.03 *#*



SECTION A-A

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WORK ORDER
NO. 65491

D3472-3 HINGE

NOTES:

- 1) MAKE FROM MS20257-3 HINGE, MODIFIED AS SHOWN
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

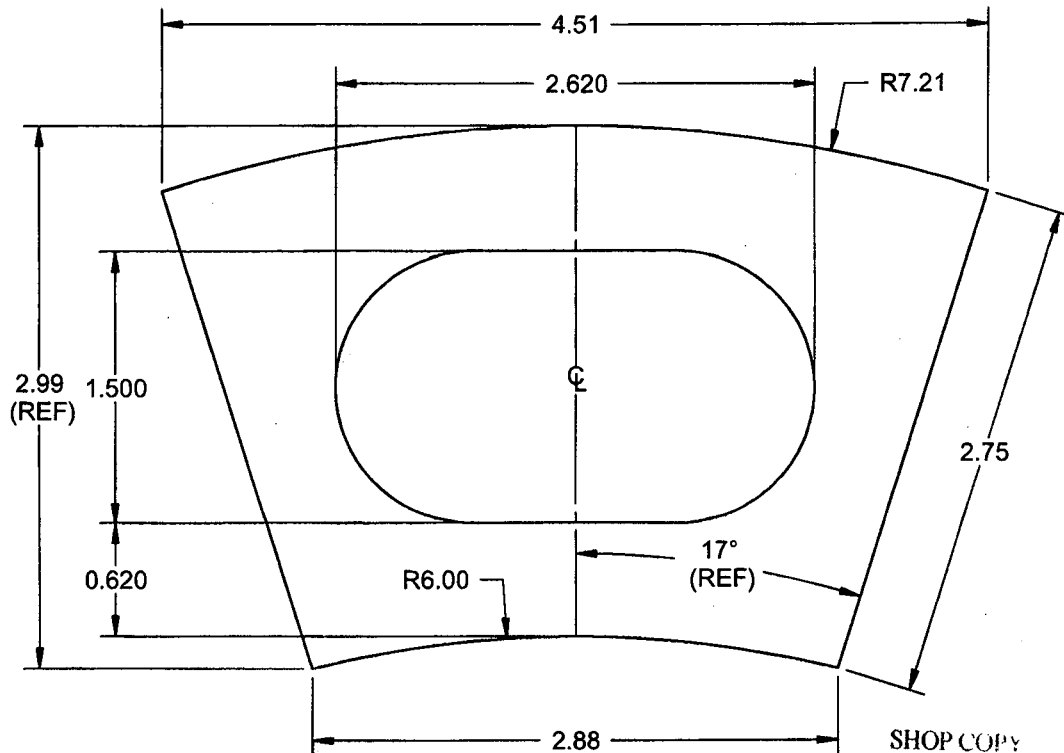
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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3472	REV. A SHEET 4 OF 4
DATE 06.01.17		TITLE HEAT OUTLET DEFLECTOR	SCALE 1:1

06-04-03 *[Signature]*



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WORK ORDER
NO. 65491

D3472-5 FLAT DOUBLER

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) IDENTIFY WITH DART P/N D3472-5 USING
FINE POINT PERMANENT INK MARKER
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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